

Date: Tuesday, 3/20/2007 1:53:33 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 31380		
Estimate Number	: 10364		
P.O. Number	: N/A	Part Number	: D3046041
This Issue	: 3/20/2007 S.O. No. : N/A	Drawing Number	: D3046 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31214	Material	: N/A
Written By	: <u>AD 07.03.20</u>	Due Date	: 4/15/2007 Qty: 20 Um: Each
Checked & Approved By	: <u>AD 07.03.20</u>		
Comment	: Est: A 01.08.27 New issue SM/EC est: B 06.11.30 Per revB, EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D30461	Lug Bracket
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 LUG BRACKET

Qty	Part Number	Description	Batch
1	D3046-1	Lug Bracket	B 31228

FC 07/04/24 (20)

2.0	D30465	HOOK
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 LUG

Pick:

Qty	Part Number	Description	Batch
1	D3046-5	Lug	B31382

FC 07/04/24 (20)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
 Weld assembly as per dwg D3046

FC 07/04/24 (20)

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

FC 07/04/24 (20)

5.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

FC 07/04/24 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/05/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 1:53:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 31380

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 3624

Heat treat Ass'y as per Dwg D3046

(Heat treat ass'y to H900 hardened condition min 190 KSI)

Possible Supplier: Vac-aero

Certificate of conformity required

C207/04/24 (20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C207/05/03 (20)

8.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure certificate of conformity comply to Dwg D3046

2004.07.20

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

04.05.08 (70)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C207/05/09 (20)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C207/05/09 (20)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

04.05.09 (20)

Job Completion



04.05.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

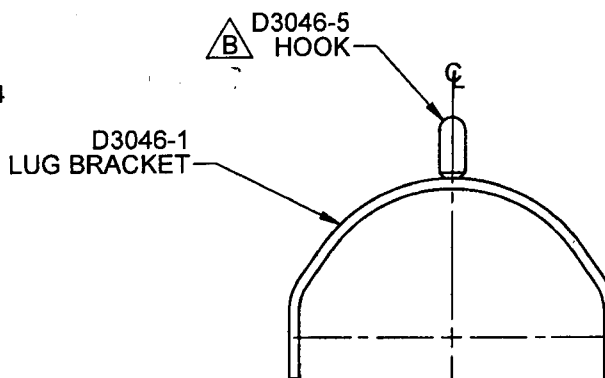
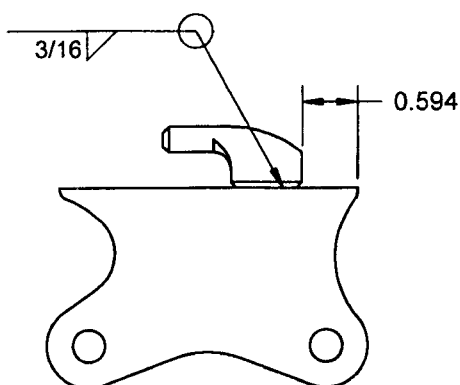
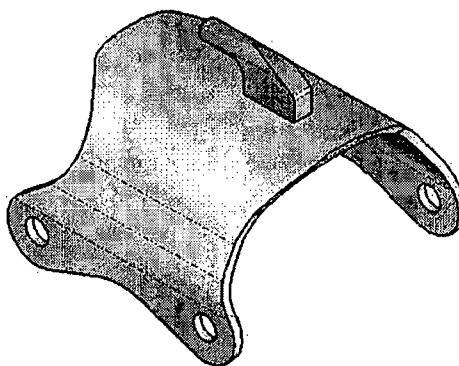
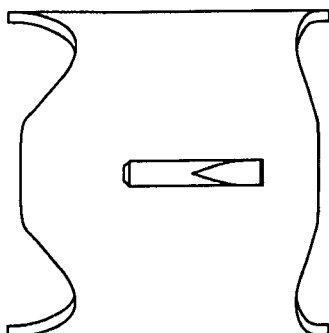
NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. B SHEET 1 OF 3
DATE 06.10.26		TITLE LUG BRACKET ASSEMBLY	SCALE 1:2
REV A	DATE 01.08.23	DESCRIPTION NEW ISSUE	
B	06.10.26	ADD D3046-5 REMOVE D3046-3; INCREASE HOLE DIAMETER OF D3046-1; CHANGE MATERIAL TO 17-4PH FROM 1010 STEEL	

RELEASED

06.11.13 #



D3046-041 LUG BRACKET ASSEMBLY

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK



NOTES:

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI) POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER

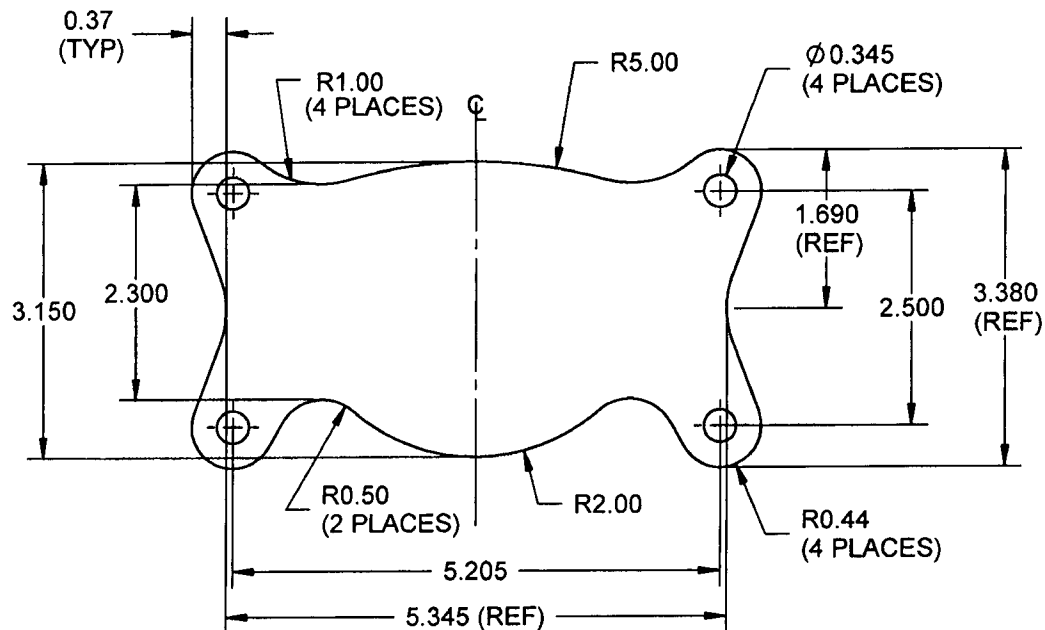
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31380

COPYRIGHT © 2001 BY DART AEROSPACE LTD

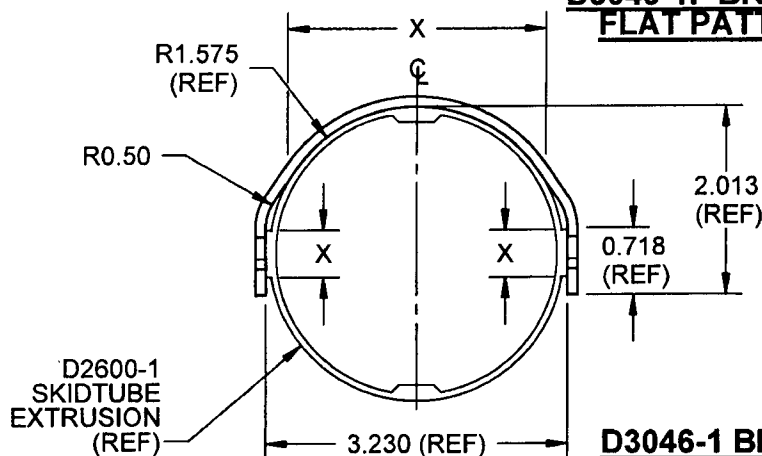
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

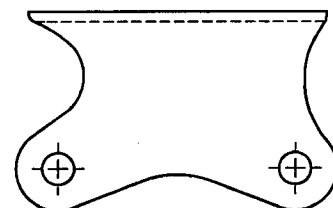
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. B SHEET 2 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY		SCALE 1:2



**D3046-1F BRACKET
FLAT PATTERN**



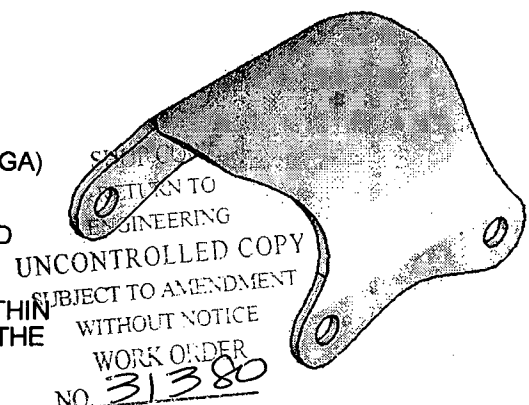
**D3046-1 BRACKET
BEND DETAIL**

**RELEASED**

06/11/13

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK
(12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.

**COPYRIGHT © 2001 BY DART AEROSPACE LTD**

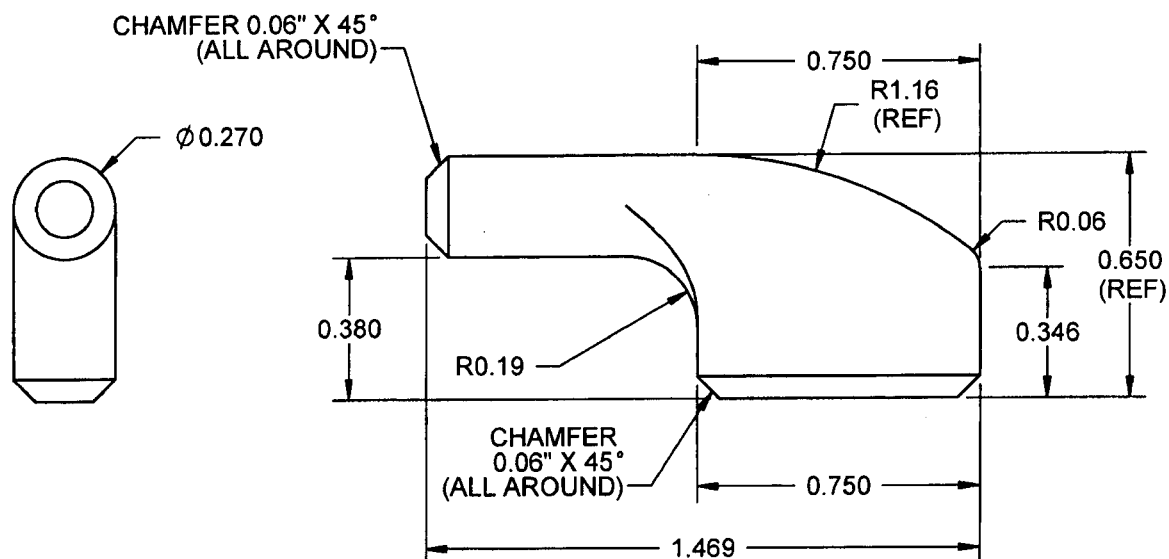
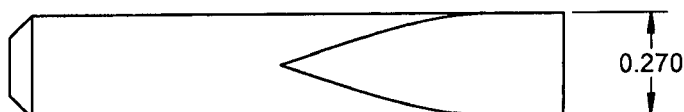
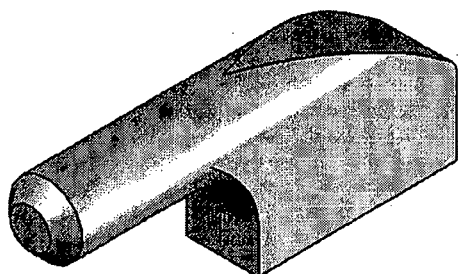
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3046	REV. B SHEET 3 OF 3
DATE 06.10.26		TITLE LUG BRACKET ASSEMBLY	SCALE 2:1

RELEASED

06.11.13



D3046-5 HOOK

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643 (REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31380

COPYRIGHT © 2001 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

OAK 86751-1

05/01/2007

MM/DD/YYYY

PAGE: 1


VAC AERO
 INTERNATIONAL INC.

 HEAD OFFICE
 1371 SPEERS ROAD, OAKVILLE, ONTARIO
 CANADA L6L 2X5
 TEL: (905) 827-4171 FAX: (905) 827-7489

 QUEBEC DIVISION
 7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
 CANADA H4S 1C5
 TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

 BILL TO: 1DAR01
 DART AEROSPACE LTD.
 1270 ABERDEEN ST.
 HAWKESBURY, ON

 SHIP TO: DART AEROSPACE LTD.
 1270 ABERDEEN ST.
 HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED		SHIP VIA	F.O.B.	
05/01/2007			ORIGIN	
CUSTOMER P/O No.		JOB No.	TERMS	
3624			COD	

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D3046	-041	EA	20	20	
		Process Specifications: Procedure: 3806 HEAT TREATED TO H900 PER AMS 2759-3D 100% HARDNESS CHECKED AS PER ASTM E-18 HRC: 40-47 MATERIAL: 17-4PH B31380 P/S# 59129				
02	MC	MINIMUM CHARGE		1	1	

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.


 VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT
 TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS
